

Date: Tuesday, 19/08/2008 4:04:33 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |  |                           |                      |
|------------------------------------|--|---------------------------|----------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services                | <b>Drawing Name</b> :     | HI-STEP LEG ASSEMBLY |
| <b>Job Number</b> :                | 41445  |                           |                      |
| <b>Estimate Number</b> :           | 10385  |                           |                      |
| <b>P.O. Number</b> :               |  | <b>Part Number</b> :      | D3065041             |
| <b>This Issue</b> :                | 19/08/2008   | <b>Drawing Number</b> :   | D3065 REV B          |
| <b>Prsht Rev.</b> :                | NC   | <b>Project Number</b> :   | N/A                  |
| <b>First Issue</b> :               | 11   | <b>Drawing Revision</b> : | B                    |
| <b>Previous Run</b> :              | 39861  | <b>Material</b> :         |                      |
| <b>Written By</b> :                |  | <b>Due Date</b> :         | 30/09/2000           |
| <b>Checked &amp; Approved By</b> : | JUL 08.8.19  |                           |                      |
| <b>Comment</b> :                   | Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF |                           |                      |

Qty: 50 Um: Each

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |             |
|-----|--------|-------------|
| 1.0 | 41445A | STEP SPACER |
|-----|--------|-------------|



Comment: Sub-Component STEP SPACER

1 x D3065-1 Batch

B39861A (47x)

B42344 (3x)

Ep 08/10/30

|     |        |             |
|-----|--------|-------------|
| 2.0 | 41445B | STEP SPACER |
|-----|--------|-------------|



Comment: Sub-Component STEP SPACER

1 x D3065-3 Batch

B39861B (33x)

B42344 (17x)

Ep 08/10/30

|     |        |          |
|-----|--------|----------|
| 3.0 | 41445C | STEP LEG |
|-----|--------|----------|



Comment: Sub-Component STEP LEG

2 x D3065-5 Batch

B39861C (13x)

B41445C (87x)

Ep 08/10/30

|     |        |             |
|-----|--------|-------------|
| 4.0 | 41445D | STEP SPACER |
|-----|--------|-------------|



Comment: Sub-Component STEP SPACER

1 x D3065-7 Batch

B38650D

Ep 08/10/30

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | MS20470AD44 | Rivet, Universal Head |
|-----|-------------|-----------------------|



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1500.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description  
 30 MS20470AD4-4 Rivet

Description  
 Rivet

Batch  
 M108377

(930x)

M109545

(570x)

Ep 08/10/30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:34 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 41445

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD

08/10/31

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-31

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

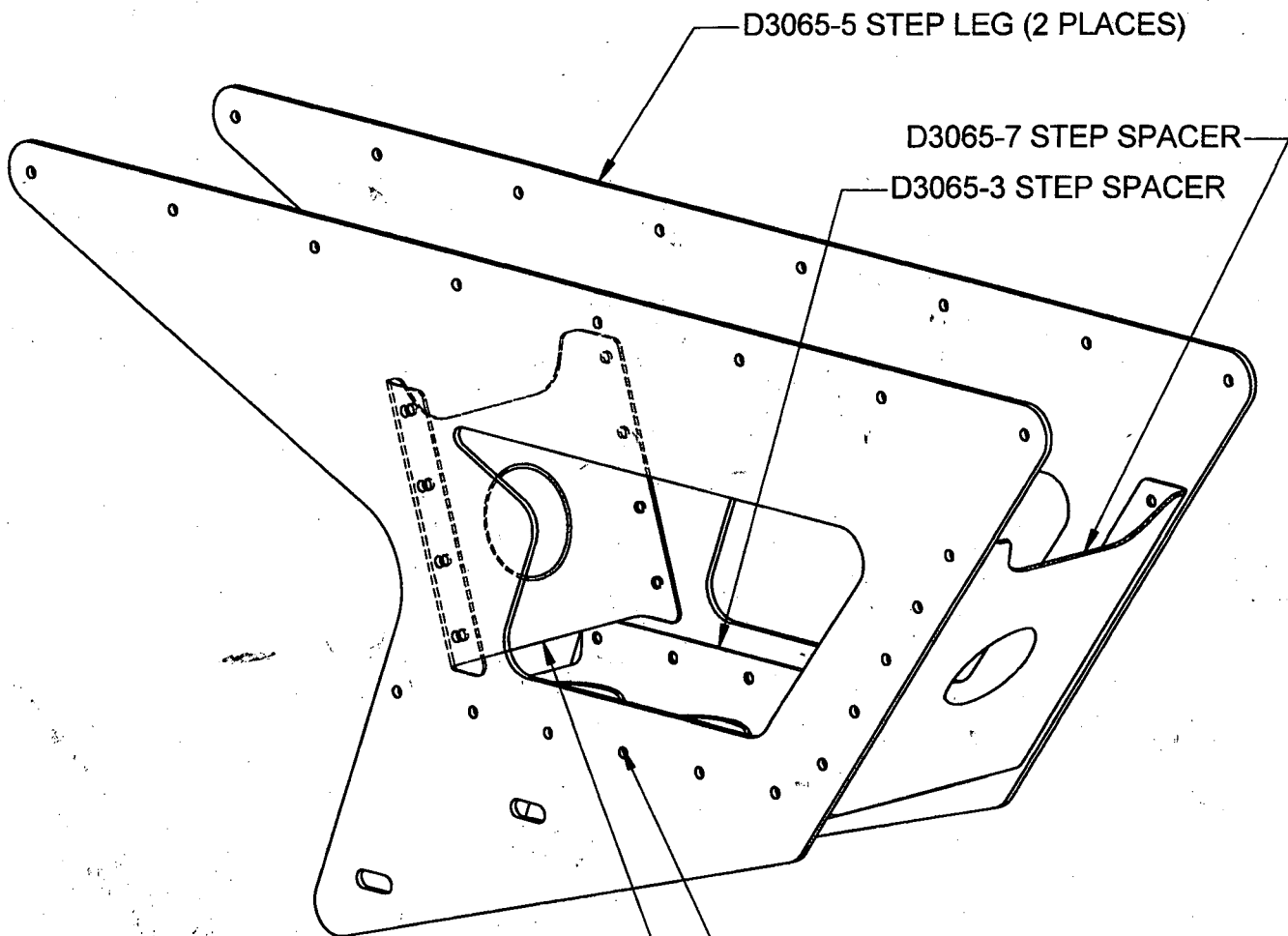
**NOTE:** Date & initial all entries



|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 1 OF 5 |
| DATE<br>06.05.23     |                                | TITLE<br>STEP LEG ASSEMBLY                        | SCALE<br>1:2           |
| A                    | 02.09.11                       | NEW ISSUE   |                        |
| B                    | 06.05.23                       | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5        |                        |

RELEASED

06.06.20 *[Signature]*



D3065-1 STEP SPACER

ASSEMBLE WITH  
MS20470AD4-4 RIVET  
(30 PLACES)

## D3065-041 STEP LEG ASSEMBLY

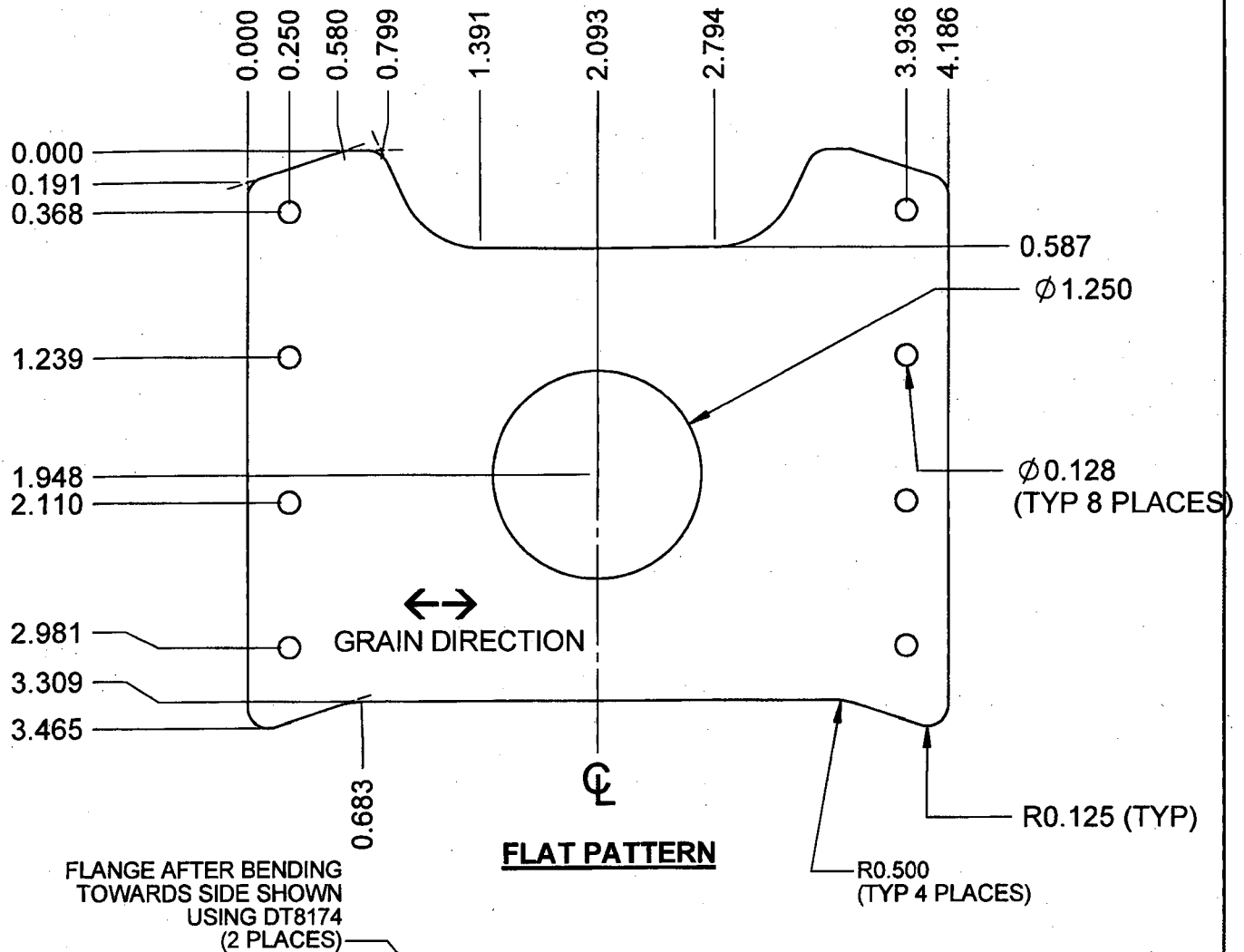
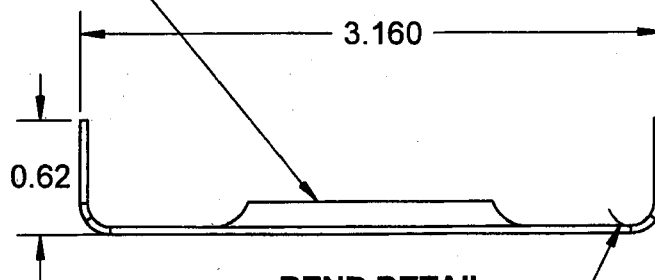
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WORK ORDER  
NO. *41445*

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| DATE<br><b>06.05.23</b> | TITLE<br><b>STEP LEG ASSEMBLY</b> |  | SCALE<br>1:1           |

**RELEASED***CP de-20 [Signature]***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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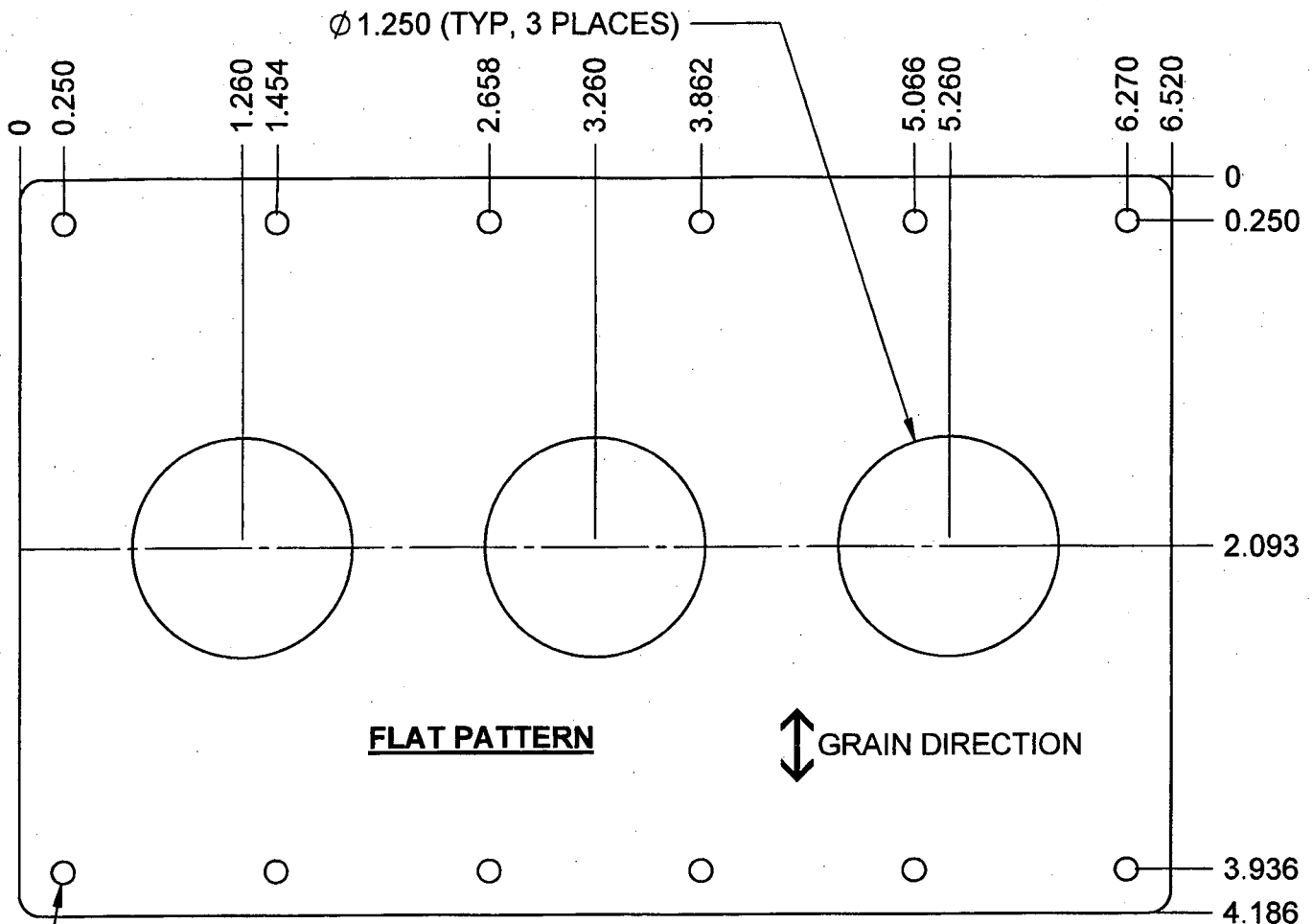
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| DATE<br><b>06.05.23</b> | TITLE<br><b>STEP LEG ASSEMBLY</b> |  | SCALE<br>1:1           |

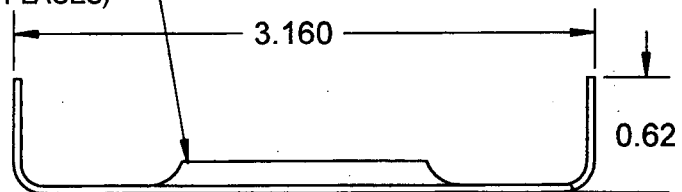


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*de de 20*



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### D3065-3 STEP SPACER

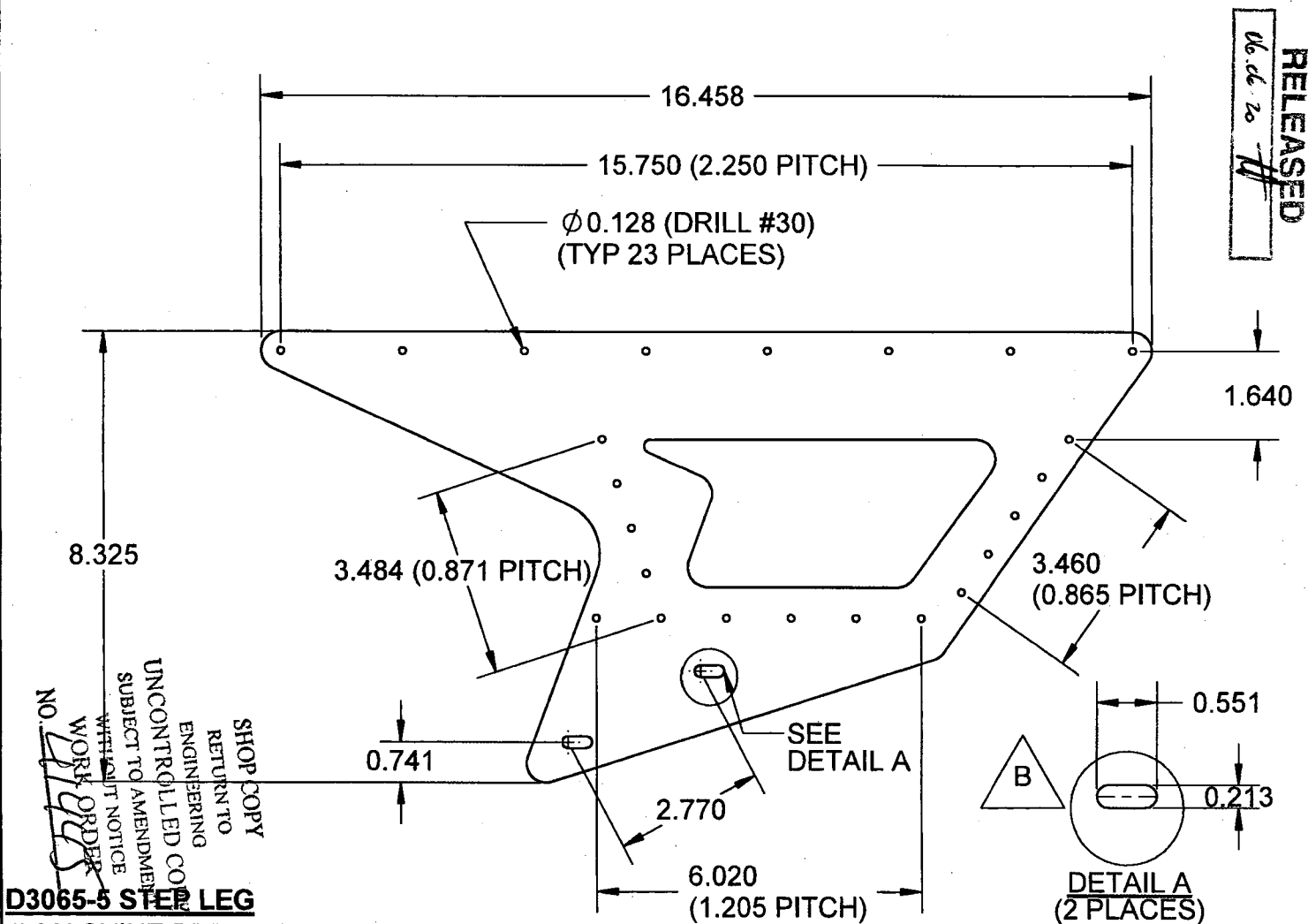
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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| 8/4      | 11       | DRAWING NO. <b>D3065</b>    |
| DATE     |          | TITLE                       |
| 06.05.23 |          | <b>STEP LEG ASSEMBLY</b>    |
|          |          | SCALE                       |
|          |          | 1:3                         |
|          |          | REV. B                      |
|          |          | SHEET 4 OF 5                |



- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

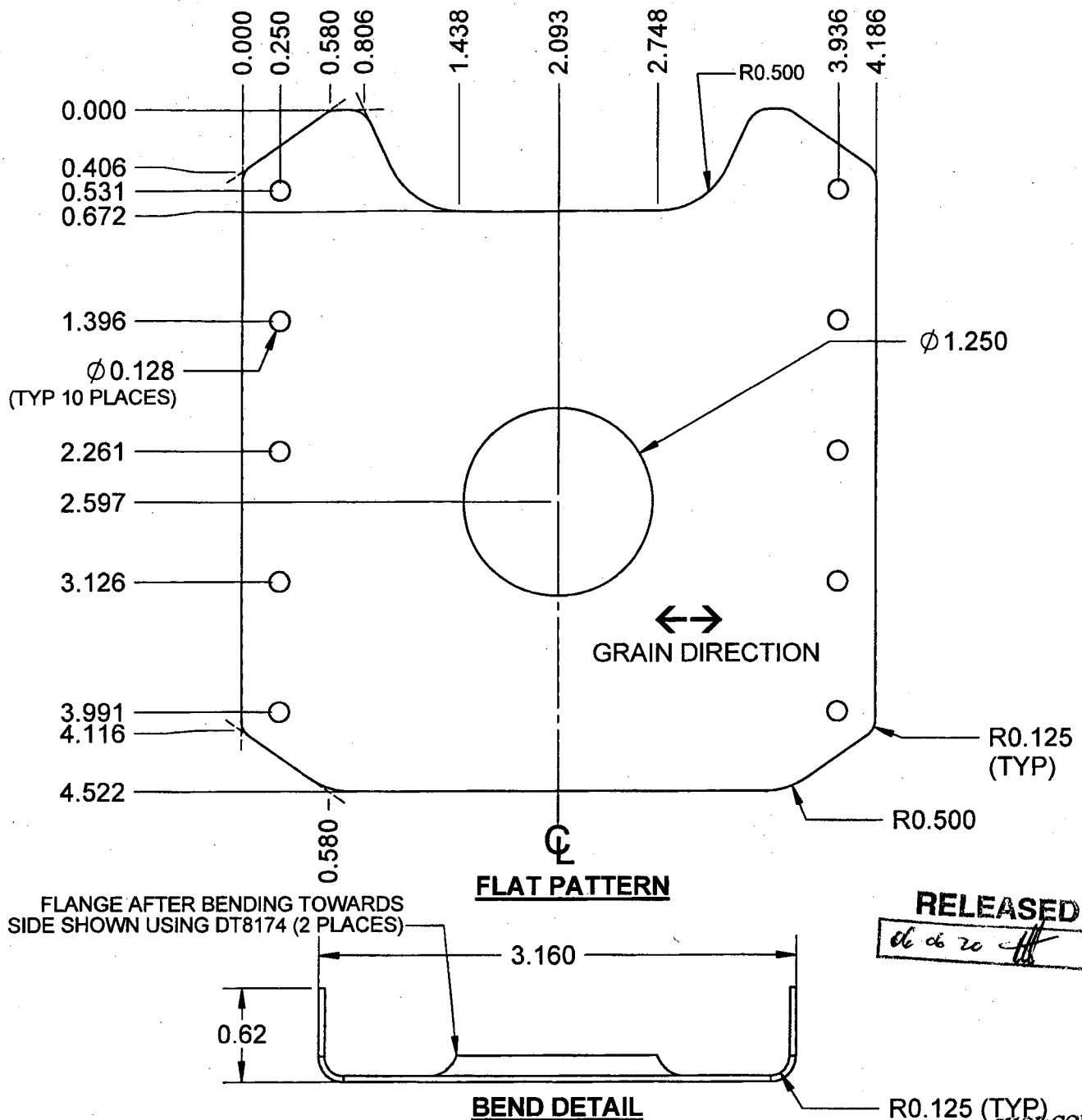
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| DATE<br><b>06.05.23</b> |                                | TITLE<br><b>STEP LEG ASSEMBLY</b>                        | SCALE<br>1:1           |



### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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